

Work Order ID 62969

Thursday, October 14, 2010 12:41:17 PM



Page 1

Item ID: D3535-35

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 10/14/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date: 10/10/14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

B 10-10-19

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-10-19

120

QC8- Inspect parts - second check

0.00



QC

Memo JH-03

0.00

Quality Control

A1272

10/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62969

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Page 2

Item ID: D3535-35

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Revision ID:

Stop



Item Name: Wearshoe

Start Date: 10/14/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



Brake NC

NC BRAKE

0.00

Memo

0.00

1-Deburr if necessary ☐ 2-Form on Brake as per Dwg D3535 using Jigs
DT8261 and DT8326. ☐ 3-Identify as D3535-35.

EP 10/10/20 (8)

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8

10.10.20

Quality Control

150



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3

0.00

Memo

0.00

START TIME: 8:35 ☐ OVEN TEMPERATURE:
300° ☐ FINISH TIME: 9:05

(8)

Powder Coating

W/O:		WORK ORDER CHANGES					
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Work Order ID 62969

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Page 3

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Stop



Item Name: Wearshoe

Start Date: 10/14/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

=> M 10/10/22

0.00

Memo

8

9

170



Packaging

Packaging

Identify as per dwg & Stock Location

FR-18

0.00

BR 10-10-22

0.00

Memo

8.

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

10/10/22
MF
10-10-22

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, October 14, 2010 12:41:21 PM

Page 1

Work Order ID: 62969



Parent Item: D3535-35



Parent Item Name: Wearshoe


Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	108.6987	0.8022	6.755368			

B1070-19

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	85.9522	
114574	10.6522	
115762	75.3	
MAT20	22.7465	
112885	2.7475	
113062	0.699	
115440	19.3	

115762

8

W/O:		WORK ORDER CHANGES					
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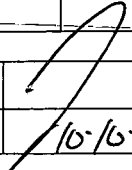
DART AEROSPACE LTD		Work Order:	62969
Description: Wearshoe		Part Number:	D3535-35
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST



☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.000	✓		V 1B02	
1.885	+/-0.010	1.888	✗		V	
6.00	+/-0.030	6.000	✓		T 1B01	
6.75	+/-0.030	6.750	✗		T	
Ø0.188	+0.005/-0.001	.193	✗		V	
23.250	+/-0.010	23.250	✓		T	
19.750	+/-0.010	19.750	✓		T	
17.750	+/-0.010	17.750	✓		T	
14.250	+/-0.010	14.250	✗		T	
9.500	+/-0.010	9.500	✓		T	
4.750	+/-0.010	4.750	✗		T	
0.300	+/-0.010	.305	✗		V	
0.300	+/-0.010	.306	✗		V	
0.038	+/-0.010	.1037	✗		V	

Measured by:	B
Date:	10-10-19

Audited by:	
Date:	10/10/19

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM 	

Dart Aerospace Ltd

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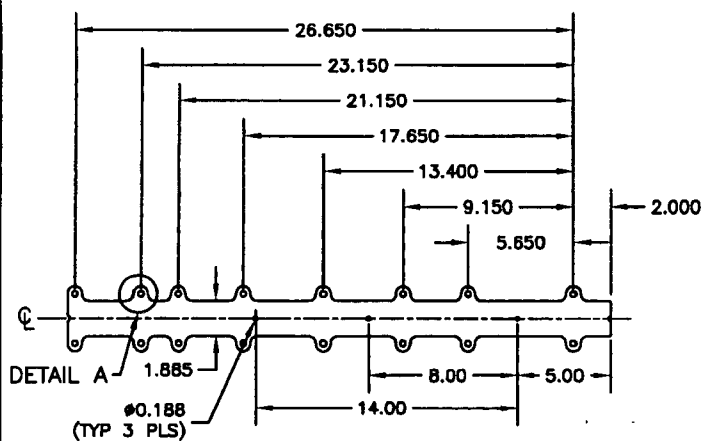
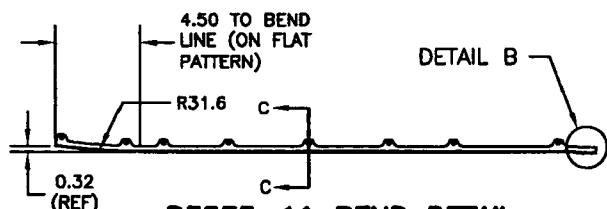
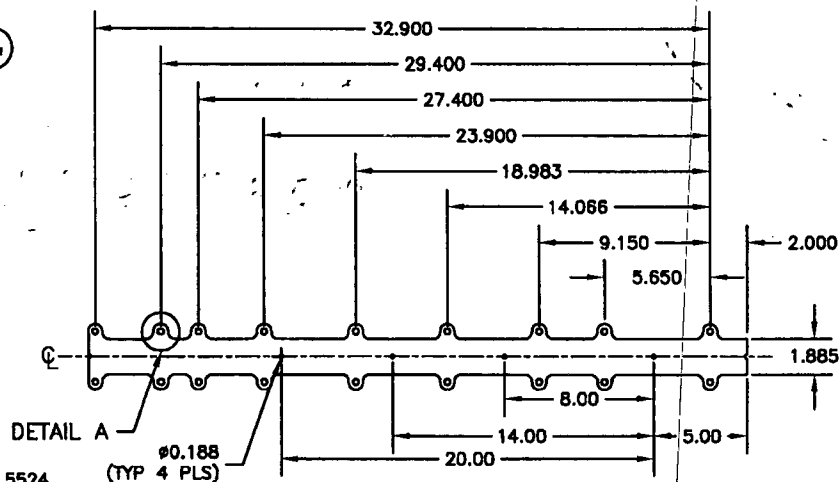
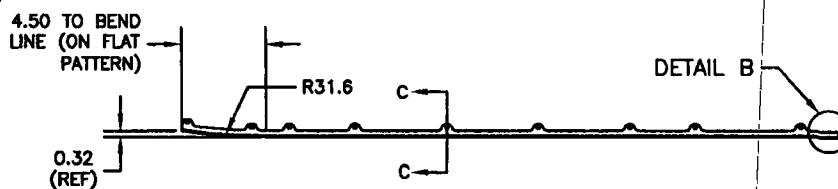
NOTE: Date & initial all entries

DART

RELEASED

07.04.24

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO A FINAL
WITHIN 1 MONTH
WORK ORDER
NO. *62969*
281010-14

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 1 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

W/O:		WORK ORDER CHANGES					
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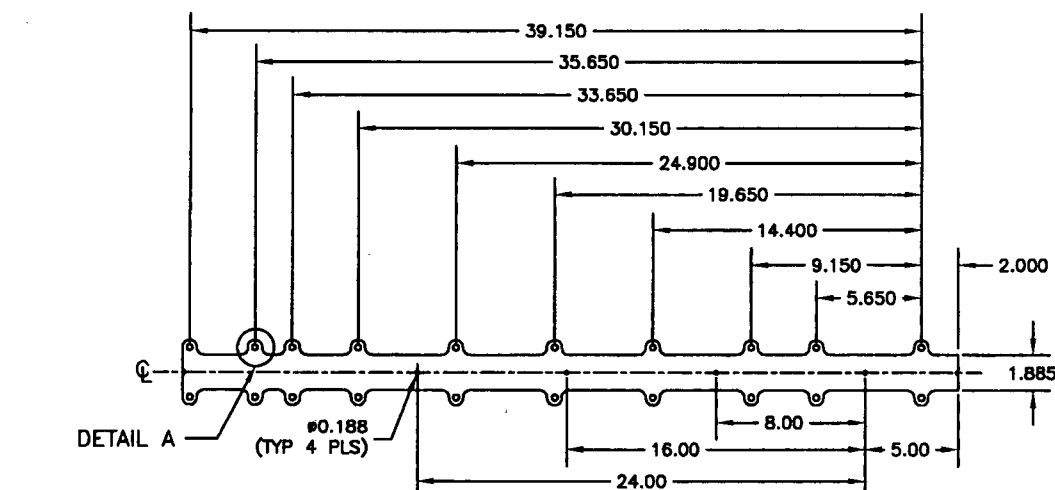
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DART

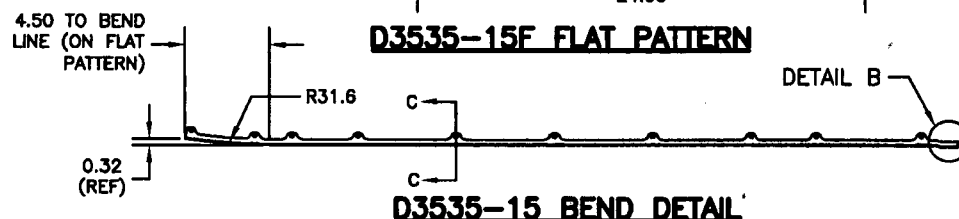
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07.04.24

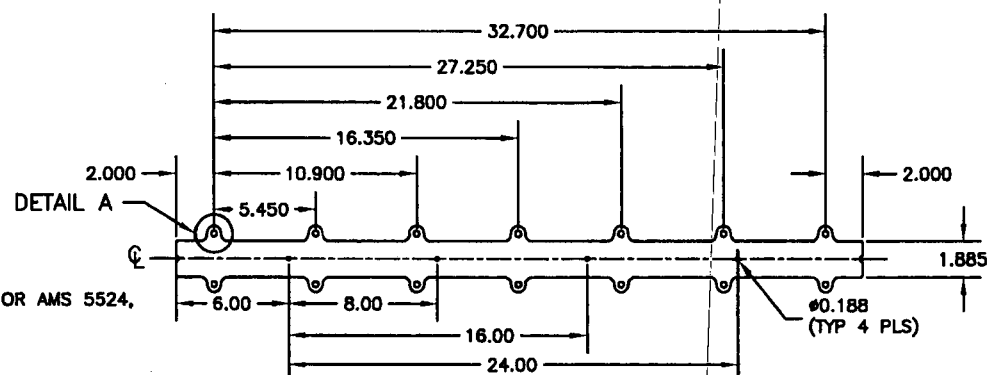
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		D3535	SHEET 2 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:10



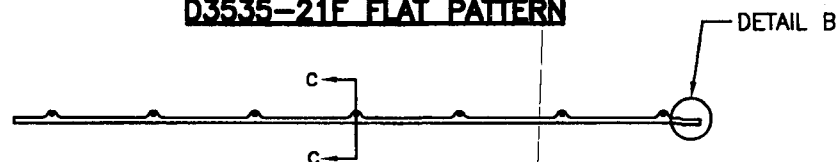
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

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Dart Aerospace Ltd

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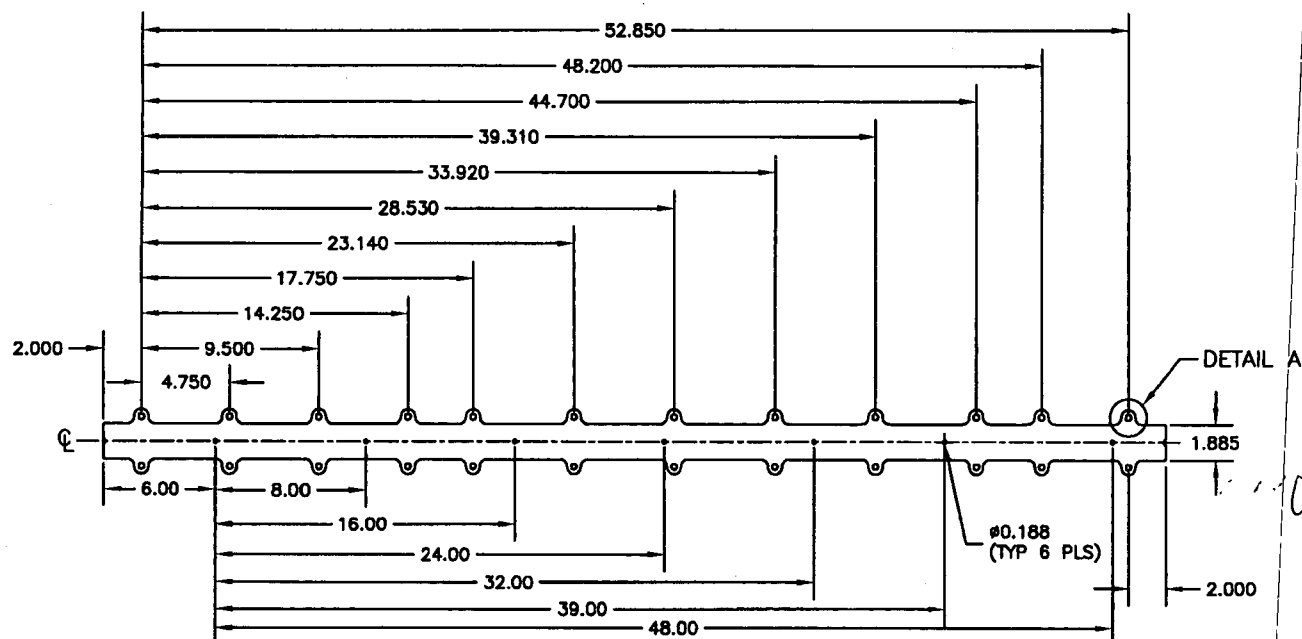
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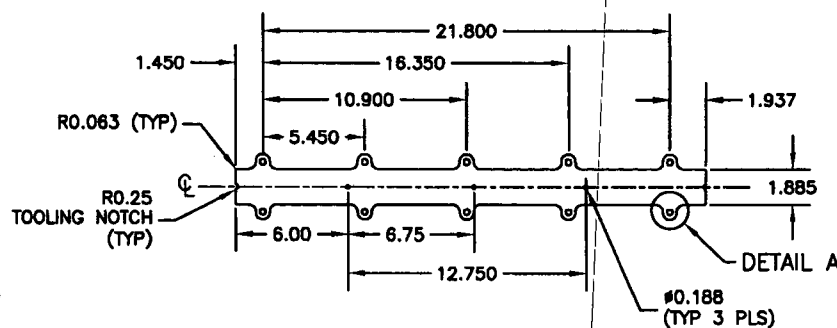
062969



D3535-23F FLAT PATTERN



D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	REVISION
		WEARSHOE		SHEET 3 OF 7
				SCALE 1:10

W/O:		WORK ORDER CHANGES					
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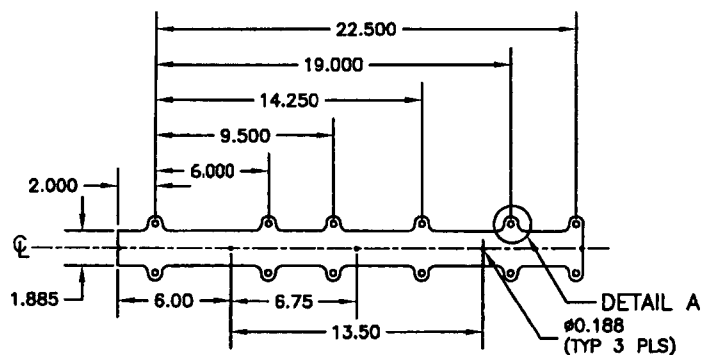
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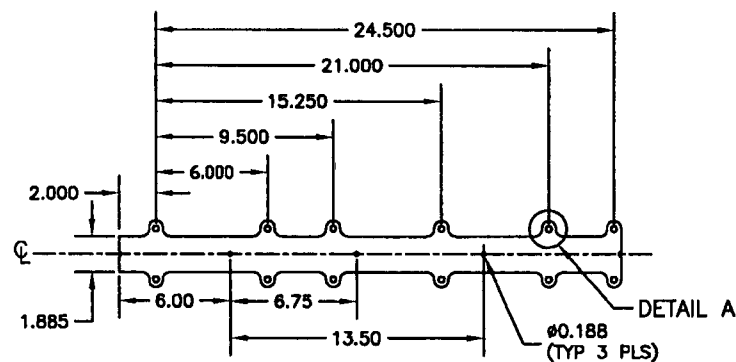
07.04.24



D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN





D3535-33 BEND DETAIL

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DATE	TITLE		SCALE			
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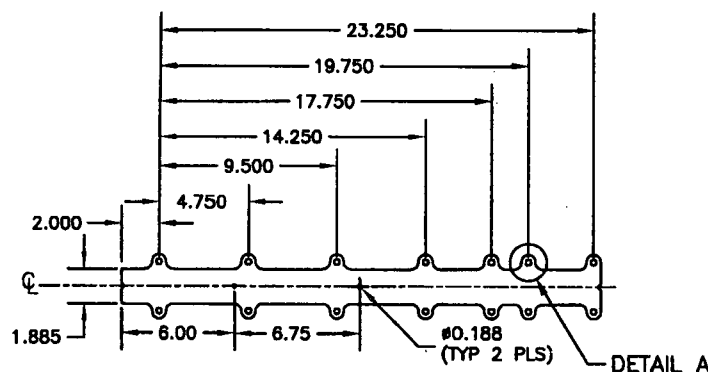
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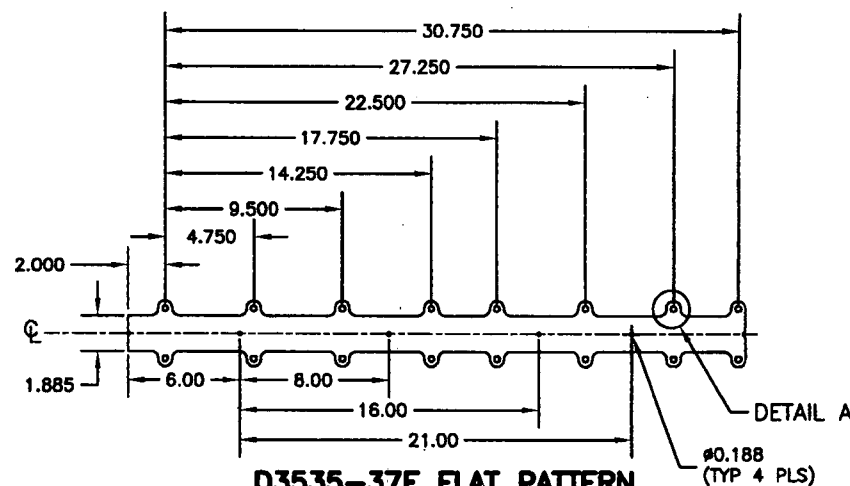
also 42969



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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DATE	07.04.17	TITLE	D3535	REV. B
			WEARSHOE	SHEET 5 OF 7
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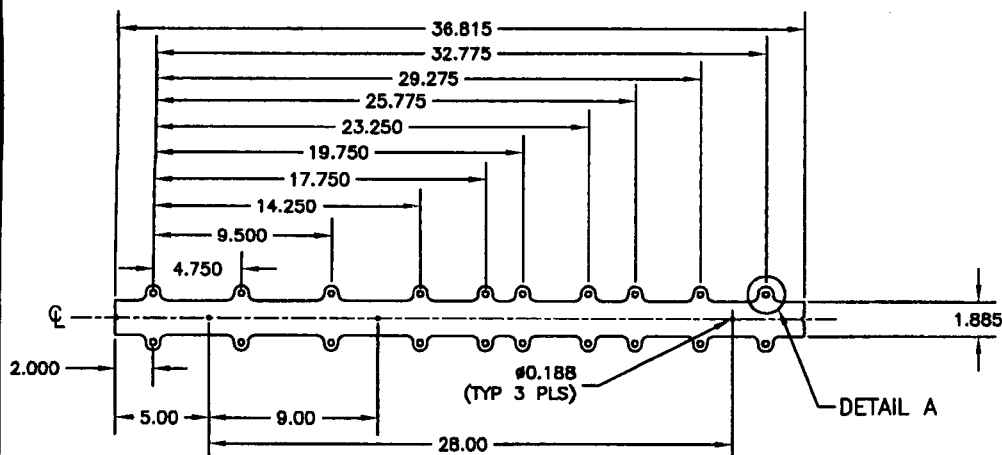
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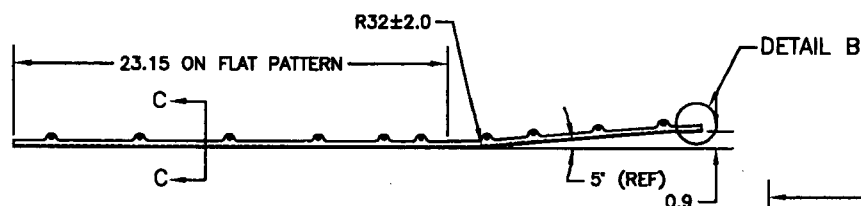
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07.04.17

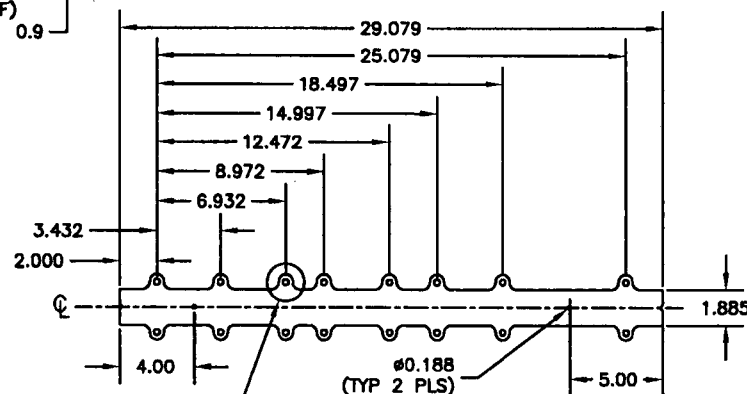
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 6 OF 7
	SCALE 1:10	



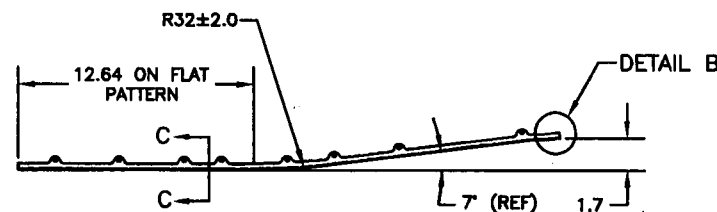
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NOTES

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

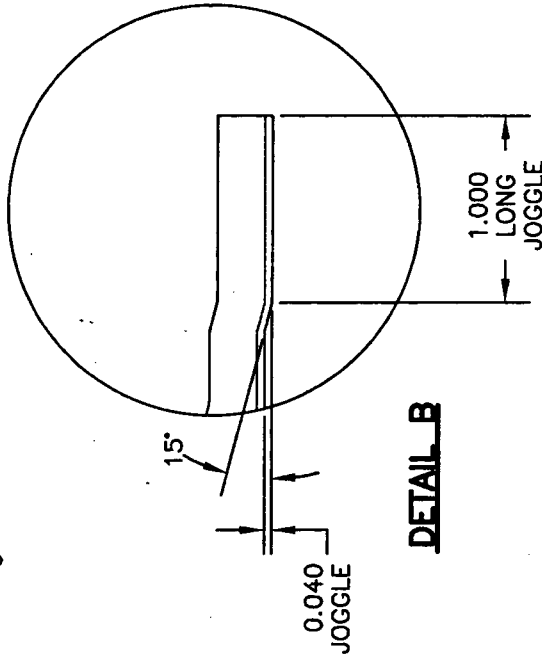


DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

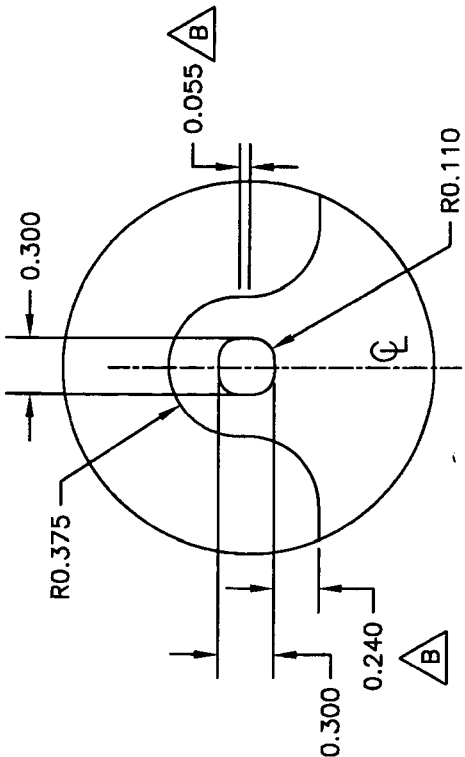
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07.04.24

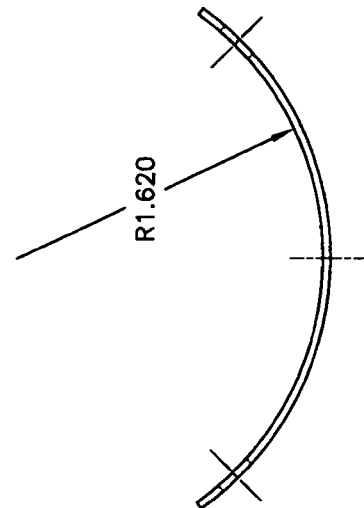
W. W. W. W. W.



DETAIL B



DETAIL A



SECTION C-C

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries